Work Order ID 97855 March-01-13 8:48:53 AM			*97855*								l
Revision ID:	D2171		Accept	*N900	040	100) * s	etup Star Stop	I V	S1* S2*	
Start Date: 3 Required Date: 1 Reference:	3/01/13 Start Qty: 3/22/13 Req'd Qty:	, ,	=	Cust Item I Customer:	D:						
Approvals:	Process Plan: ML5	Date: /2-03	?-() Tooling:	Da	ate:		R	tun Star	1/1	R1*	
	QC:	• •		Da	ate:			Stop	` *N	R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	•
. Draw Nbr	Revision Nbr										
D2171	Rev D	a diamental planetar								Ω4	
*100	PURCHASING	<u> </u>	0.00				20			05	2 B D
Waterjet	М	emo .	0.00				_& O				J 0 J 46
FLOW CNC Waterje	Dy	Cut as per Dwg wg Rev: og Rev:									
	2-3	Deburr if necessary	•								
110 * 11 0*	QC2- Inspect p	parts off machine FAI/FAIB	0.00				20		í	DAS 05	12026

0.00

Memo

Quality Control

Work Order ID 97855 March-01-13 8:48:53 AM				*97	855*							Page 2
Item ID: Revision ID: Item Name: Start Date: Required Date	D2171 Clamp 3/01/13 : 3/22/13	Start Qty: 20.00 Req'd Qty: 20.00		Accept 20* 20*	*N900 Cust Item Customer	iD:	100) *	Setup	Start Stop	171	S1* S2*
Reference:									D	Start		
Approvals:	Process Pl	lan:	Date:	Tooling:		Date:			Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):]	Date:				Stop	*N	R2*
Sequence ID/ Work Center I 120 *120* QC	D	Operation Description QC8- Inspect parts - secon	nd check	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Qt		Reject Number	Insp. Stamp OAS 09
130 *130* Brake NC Brake NC		Form as per dwg Small Fab Memo 1- remove pr	ress and machin	0.00 0.00 e marking as necessary				20				SB 13/03
140 *14 CC QC Quality Control		QC5- Inspect part comple	eteness to step o	0.00	3.13			20			<u></u>	

Work Ord March-01-13 &		855		*978	355*							Page 3	
Item ID: Revision ID: Item Name: Start Date:	D2171 Clamp 3/01/13	Start Qty: 20.00	*20:	Accept	*N900		100)* S	etup	Start Stop	171	S1* S2*	An
Required Date Reference:	e: 3/22/13	Req'd Qty: 20.00	*20		Customer:					.			
Approvals:	Process Pla	nn:	Date:	Tooling: SPC (Y/N):		ate:		R	un	Start Stop	171	R1* R2*	
Sequence ID/ Work Center 150 *150* Packaging Packaging	ID	Operation Description Identify as per dwg & Sto	ck Location:	Set Up/ Run Hours 456 5.00	Tool ID	Tool #	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp	-3-
160 *160*		QC21- Final Inspection -	Work Order Release	0.00					12	3/2	لرزل	A	

0.00

Memo

Quality Control

pl 13-05-13

Picklist Print

March-01-13 8:48:52 AM

Work Order ID: Parent Item:

97855 D2171

Parent Item Name:

Clamp

Start Date: 3/01/13

Required Date: 3/22/13

Start Qty: 20.00

Required Qty: 20.00

IPP REV:A 11.04.26 now made in house DD verf:EC Comments: Component Item ID/ Unit of Qty on Replacement Mfg/ Primary Last Bin Route

Qty per Kit Total Qty Status Date Item Name Location Measure Hand Issued Issued Seq ID Item ID Purch Location Qty Item 100 sf 589.6560 0.02580.5431579 M304S16GA No Purchased 13 03 06 304/316 Sheet .063

Location	Loc Qty	Loc Code	
MAT020	589.656		
122245	5.156		
123136	140.8		
124428	123.7		
124572	320		

DART AEROSPACE LTD	Work Order:	97855
Description: Clamp	Part Number:	D2171
Inspection Dwg: D2171 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	0.257	V		VEW	MN-01
0.75	+/-0.030	0.75 0.406 4.966	/		Vern	// *
0.40	+/-0.030	0.406	V		Verv	11 11
4.968	+/-0.010	4.966	V		Verv	11 "
4.158	+/-0.010	4.157	/		Vern Vern Vern	// ``
				-		
					·	
						-
			68.׺			

Measured by:	MM	Audited by:	NO	Prototype Approval:	N/A
Date:	13.03.06	Date:	13-03-06	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.06.16	New Issue	KJ/DD 🚓	





DESIG	BW	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECH	(ED _ C)	APPROYED	DRAWING NO. REV.	D
		KE	D2171 SHEET 1 OF	1
DATE		· · · · · · · · · · · · · · · · · · ·	TITLE SCA	LΕ
99.0	3.08		CLAMP 1	1:1
В		96.01.29	REDRAWN	
С		97.05.14	RADIUS CHANGED, CUSHION ADDED	
D		99.03.08	REMOVE CUSHION (TSR A890) 4.158 WAS 4.888	





